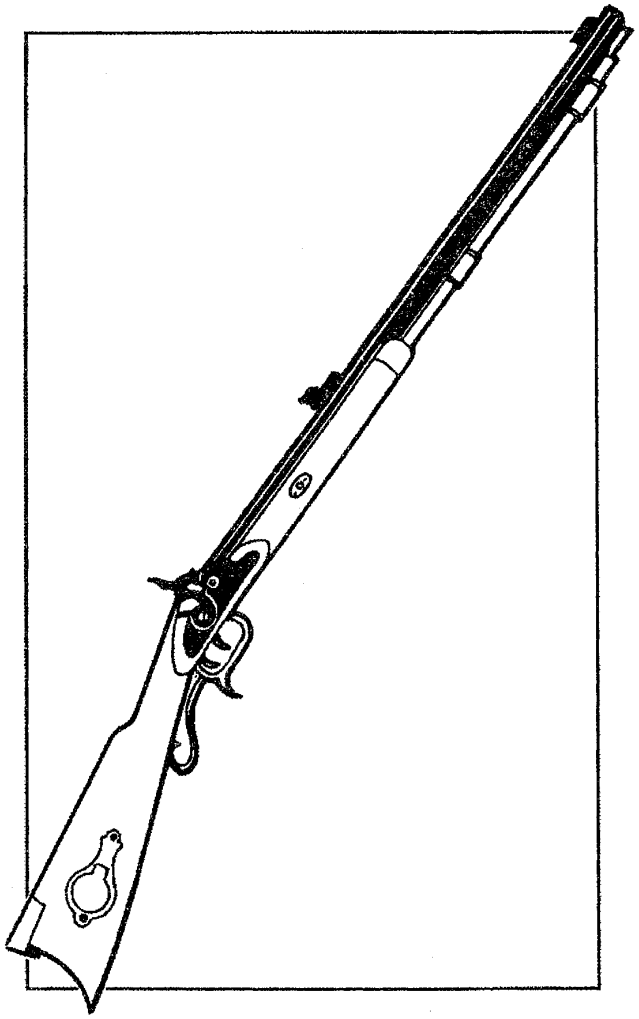
TRADITIONS™

PERFORMANCE MUZZLELOADING

Assembly Instructions
Hawken Rifle Kit

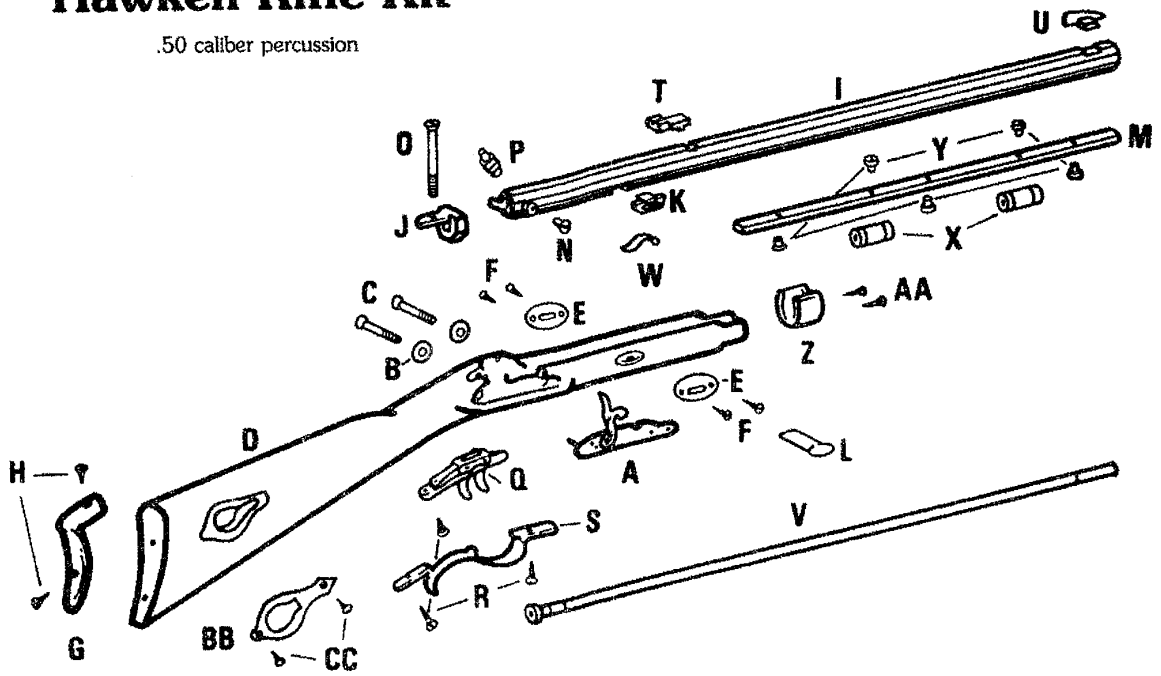


1375 Boston Post Road
P.O. Box 776
Old Saybrook, CT 06475-0776

FIT-28

Hawken Rifle Kit

.50 caliber percussion

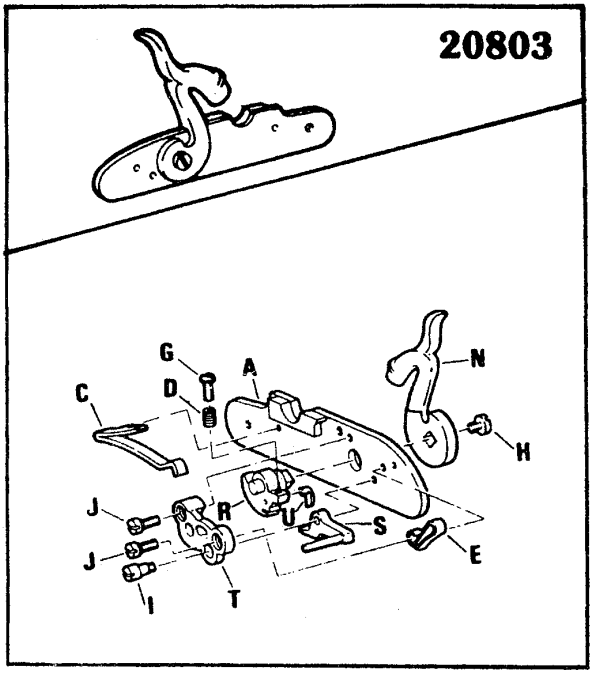


Letter	Description	Number
A	Lock - percussion	20803
B	Lock Plate Washer (2)	20840
C	Lock Plate Screw (2)	20620
D	Stock	24001
E	Stock Plate (2)	20616
F	Stock Plate Screw (4)	20617
G	Butt Plate	24026
H	Butt Plate Screw (2)	20627
I	Barrel Assembly* .50 cal. percussion	B24020
J	Barrel Tang	20606
K	Barrel Tenon	20533
L	Barrel Tenon Wedge	20618
M	Barrel Rib	24012
N	Bolster Screw-percussion only	20605
O	Tang Screw	20609

Letter	Description	Number
P	Nipple	20608
Q	Double Set Trigger	20622R
R	Trigger Assembly/ Guard Screw (3)	20624
S	Trigger Guard	20823
T	Rear Sight Assembly	30610
U	Front Sight	30611
V	Ramrod Assembly	20628
W	Ramrod Spring	20621
X	Ramrod Thimble (2)	20613
Y	Thimble/Barrel Rib Screw (5)	20614
Z	Nose Cap	24015
AA	Nose Cap Screw (2)	20625
BB	Patchbox	20435
CC	Patchbox Screw (2)	21036

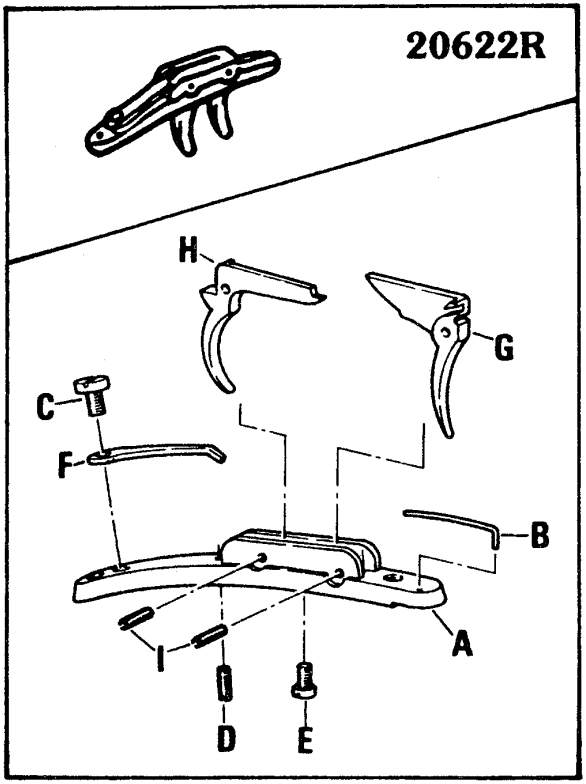
*Barrel sold only as assembly. Drum not sold separately.
Important: Do not remove Bolster/Drum from the barrel.

Lock Assembly No. 20803



Letter	Description	Number
A	Lock Plate	70801
C	Mainspring	70505
D	Sear Adjusting Screw Spring	70520
E	Sear Spring	70506
G	Sear Adjusting Screw	70518
H	Hammer Screw	70512
I	Sear Screw	70514
J	Sear Spring & Bridle Screw (2)	70515
N	Hammer	70802
R	Tumbler	70503
S	Sear	70504
T	Bridle	70508
U	Fly	70511

Double Set Trigger Assembly No. 20622R



Letter	Description	Number
A	Plate	60601
B	Front Spring	60605
C	Rear Spring Screw	60606
D	Rear Spring Tension Screw	60607
E	Front Trigger Adjustment Screw	60608
F	Rear Spring	60604
G	Front Trigger	60602
H	Rear Trigger	60603
I	Trigger Pin (2)	60609

Assembly Instructions

You should be aware that you are about to build a muzzleloader which will be fully shootable. For this reason it must be handled with the same precautions as any firearm. Before loading or shooting this gun, refer to the enclosed booklet "LIFETIME MECHANICAL WARRANTY AND MUZZLELOADING SHOOTING INSTRUCTIONS" AND READ CAREFULLY THE SECTIONS "MUZZLELOADING MUSTS", "LOADING AND SHOOTING INSTRUCTIONS", AND "RECOMMENDED LOADS". **If this booklet is not with your kit, ask your dealer or write to Traditions inc. for a free copy.**

Before working on your TRADITIONS rifle kit, inspect carefully the component parts and the terms of the Limited Lifetime Mechanical Warranty in the enclosed booklet. Please be aware that the warranty covers only UNWORKED parts of this kit.

The following instructions will enable a moderately handy person to build a safe, serviceable and shootable muzzleloader. Greater skills and patience will be rewarded with a truly fine replica of the muzzleloading era. *Please read through the instructions before beginning to work on your kit.*

I Assembly Instructions, General

A. Fitting: All metal parts should be placed into the stock snugly, removing a minimum of wood as needed with a sharp chisel or carving tool.

B. Wood Screws: To facilitate assembly and to avoid cracking the stock, small pilot holes should be drilled before inserting wood screws.

C. Metal Screws: Turn screws into and out of their threaded holes several times to insure smooth fit.

II Lock and Barrel Assembly

A. Insert lock into stock.

B. Install lock plate screws and washers. If holes are not perfectly aligned, enlarge one or both stock holes with a round file or drill to permit alignment. Screws should be flush with the lock plate; file off any extra.

C. Insert nipple and bolster screw into barrel bolster. Join tang and barrel, filing barrel hook surfaces as needed for a smooth, flush fit. Place barrel into stock, The barrel bolster should fit snugly into its place in the lock plate and the lock plate should be snug against the barrel.

D. Install and tighten trigger and tang screw as in IV below.

E. Lock hammer should fall squarely on the nipple. If it does not, one or more of the following steps may be taken:

1. Remove wood from bottom of lock recess until lock is flush with the barrel.
2. Remove wood as needed from under and behind the barrel channel, including tang area.
3. If proper alignment is not obtained with the steps above, the hammer may be bent slightly by removing it from the lock, heating it to a bright red with a torch, and bending it carefully in a vise to obtain the correct alignment.

WARNING: NEVER attempt to change the position of the barrel bolster in the barrel. This would create a DANGEROUS situation as well as voiding the warranty.

III Barrel Dovetail

Barrel tenon should fit snugly. If necessary, enlarge dovetail slot with a triangular file or reduce it slightly by indenting the barrel surface at one or both top edges with a hammer and punch.

IV Trigger and Tang Screw Installation

A. Before assembling to the wood, see that tang screw fits smoothly into its threaded hole in the trigger plate; turning it in and out several times.

B. Place trigger assembly into its stock inlet, removing wood as necessary so that no moving part contacts the wood. Insure that the wire spring in front of the trigger assembly does not touch any wood.

C. Insert and tighten the tang screw until barrel bolster is drawn snugly into its place in the lock plate and trigger functions smoothly.

D. In the event tang screw does not align properly, enlarge hole in the stock with a round file or drill.

E. IMPORTANT SAFETY PRECAUTION.

With lock, barrel and trigger assembled and all screws tightened, the lock hammer should remain securely in its half cock position and pulling the trigger should not cause the hammer to fall. The hammer should also remain in the full cock position until the front trigger is firmly pulled. If the lock and trigger do not function properly in both positions, remove the lock and make the following adjustments:

1. With vise grips or pliers, bend slightly upward the sear arm on the back of the lock. This arm is contacted by the trigger when firing. Do not bend this piece too much.
2. Remove wood as necessary inside the lock plate recess to eliminate any binding of the moving parts of the lock.

V Sights

A. Install all dovetailed sights as in Section IV above.

B. Note: Final fitting of all sights should be done only after bluing or browning the barrel.

VI Tenon Wedge Assembly

A. Secure barrel in channel and tighten tang screw.

B. Insert tenon wedge through stock and tenon. Wedge should be snug but stock opening can be slightly enlarged if necessary.

C. Remove tenon wedge and fit both brass stock plates.

D. Reinsert tenon wedge. If brass stock plate interferes, file away sufficient metal to permit insertion.

VII Brass to Wood Assembly

A. Trigger Guard

1. Press rear of trigger guard into stock. Then press front into its inlet. Pressure on the front of the guard will be required to obtain this fit.
2. If necessary the stock inlet for the rear of the guard may be lengthened slightly.
3. Insert and tighten trigger guard screws.

B. Nose Cap

1. With barrel attached to stock, place nose cap on stock. Insert and tighten two screws.
2. Wood should be removed as needed for tight fit of nose cap against barrel.

C. Butt Plate

1. Center butt plate on stock so that it either butts to or overlaps the wood. Contours of plate and stock should match as closely as possible.
2. Attach with two wood screws carefully.
3. File away excess brass before sanding stock.

D. Patchbox

1. Press patchbox into stock removing wood as necessary.
2. Insert and tighten two patchbox screws.

VIII Other Assembly

A. Thimble & Rib Assembly

1. Assemble ramrod thimbles to the barrel rib with 2 thimble/barrel rib screws.
2. Assemble barrel rib to barrel with remaining three thimble/barrel rib screws.

B. Ramrod Spring

1. Insert front lockplate washer screw through spring lying in the direction indicated in the diagram.
2. Ramrod tightness may be adjusted by bending the spring gently. Spring may be omitted, if ramrod is secure without it.

IX Finishing of Wood and Metal

A. Using wood rasp and/or sandpaper, bring wood surfaces flush with metal parts.

B. Remove or tape over metal parts to stain and finish the stock as desired.

C. Polish brass and bare steel parts with different grits of emery cloth, each one finer than the previous. Finish with fine grade steel wool.

D. Brown or blue bare steel parts with chemicals available in most gun shops.